

Work Order ID 68268

Monday, April 11, 2011 10:37:50 AM



Page 1

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 4/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

unc

Date:

11-04-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3195

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 1.500") x 3.60" long

*unc 11/04/14**4 0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3195-3 as per Folio FA334 and Dwg D3195-3□2-Deburr

*B.A 11/04/15**4 0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B.A 11/04/15**4 0*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 68268




Monday, April 11, 2011 10:37:50 AM



Page 2

Item ID: D3195-043 Accept  Setup Start 
Revision ID: Stop 
Item Name: Bracket Assembly
Start Date: 4/11/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 4/15/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>owl 11/04/15</i>		<u>4</u>	<u>0</u>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>4</u>	<u>0</u>	<u>110418</u>	
150  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>1115128</i> Memo START TIME: <u>9:00</u> <u>930</u> FINISH TIME: <u>320°</u>	0.00 0.00				<u>11</u>	<u>04</u>	<u>19</u>	<u>(4)</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68268

Monday, April 11, 2011 10:37:50 AM



Page 3

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 4/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

4 0 20 v 6/19

170



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1-Lightly Sand bonding surface 2-Bond D3195-7 into D3195-13as per Dwg
D3195 A/RContact Cement

M11095

E7 m.f

(4X)

11/04/19

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SB 11/04/19

(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68268

Monday, April 11, 2011 10:37:50 AM



Page 4

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 4/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 246A

0.00



Packaging

Memo

0.00

Packaging

11/4/19sf (4)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/19sfmf11-04-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

NOTE: Date & initial all entries

Picklist Print

Monday, April 11, 2011 10:37:56 AM

Page 1

Work Order ID: 68268

Parent Item: D3195-043

Parent Item Name: Bracket Assembly

Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3195-7 Manufactured No

100

Each

7.0000

1

4



Pad



5B 11/04/19

(4)

Location

Loc Qty

Loc Code

GA

7

51569

3

64534

4

3

1

M6061T6B1.500X01.25
0

Purchased

No

170

f

15.4700

0.3

1.263158



6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT004

15.47

107461

0.9

110936

14.57

1.263 11/04/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68268
Description: Bracket		Part Number:	D3195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.433	✓		Vern	GA-01
1.265	+/-0.010	1.261	✓		"	"
R0.37	+/-0.030	R0.375	✓		R-G	ref.
Ø0.277	+0.005/-0.000	Ø0.278	✓		Vern	GA-01
2.677	+/-0.005	2.676	✓		"	"
0.242	+/-0.010	0.246	✓		"	"
0.377	+/-0.010	0.378	✓		"	"
0.500	+/-0.010	0.501	✓		"	"
R0.188	+/-0.010	R0.188	✓		R-G	ref.
0.250	+/-0.010	0.251	✓		Vern	GA-01
0.882	+/-0.010	0.883	✓		"	"
1.250	+/-0.010	1.251	✓		"	"
0.500	+/-0.010	0.501	✓		"	"
Ø0.191	+0.005/-0.000	Ø0.193	✓		"	"
1.000	+/-0.010	1.002	✓		"	"

Measured by: K.A.	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11/04/15	Date: 11/04/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

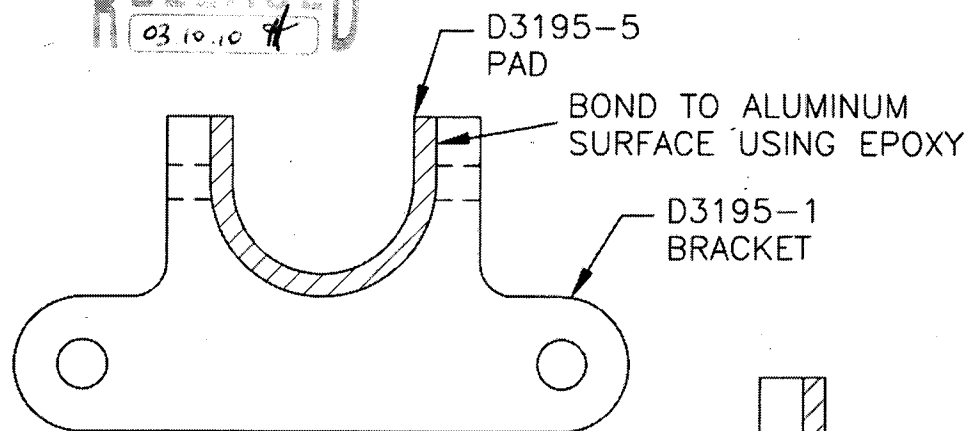
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

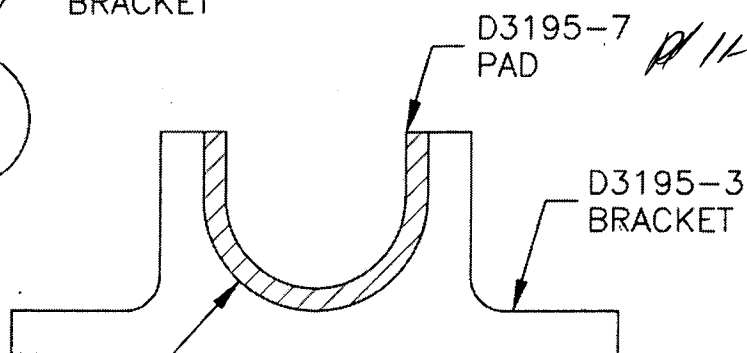


DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE 03.06.23				TITLE BRACKET	SCALE 1:1
A	03.06.23			NEW ISSUE	

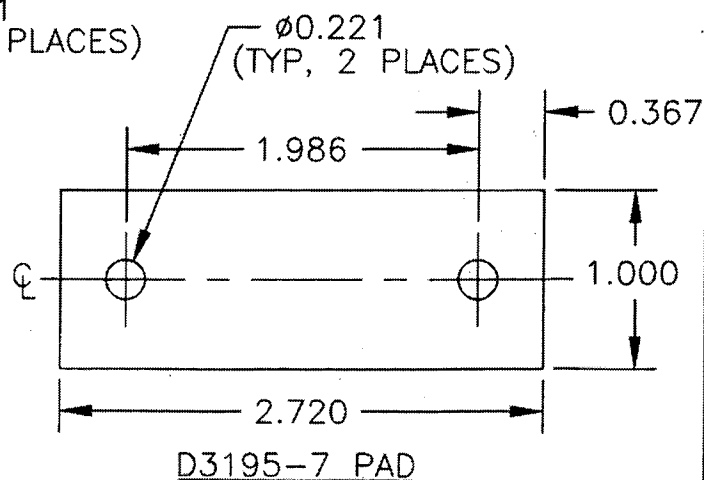
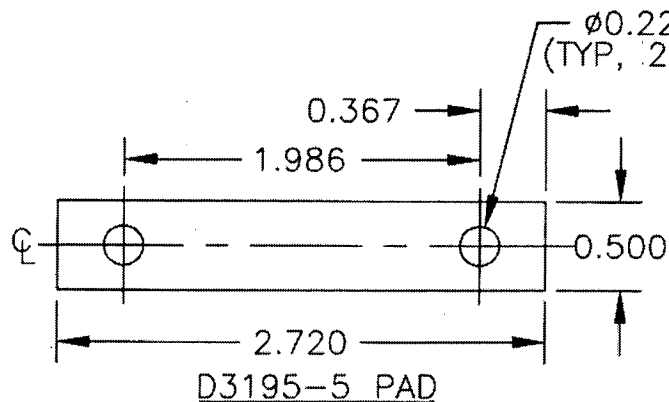
RELEASED
03.10.10 *#*



D3195-041
BRACKET



D3195-043
BRACKET



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *68448*

#1104-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

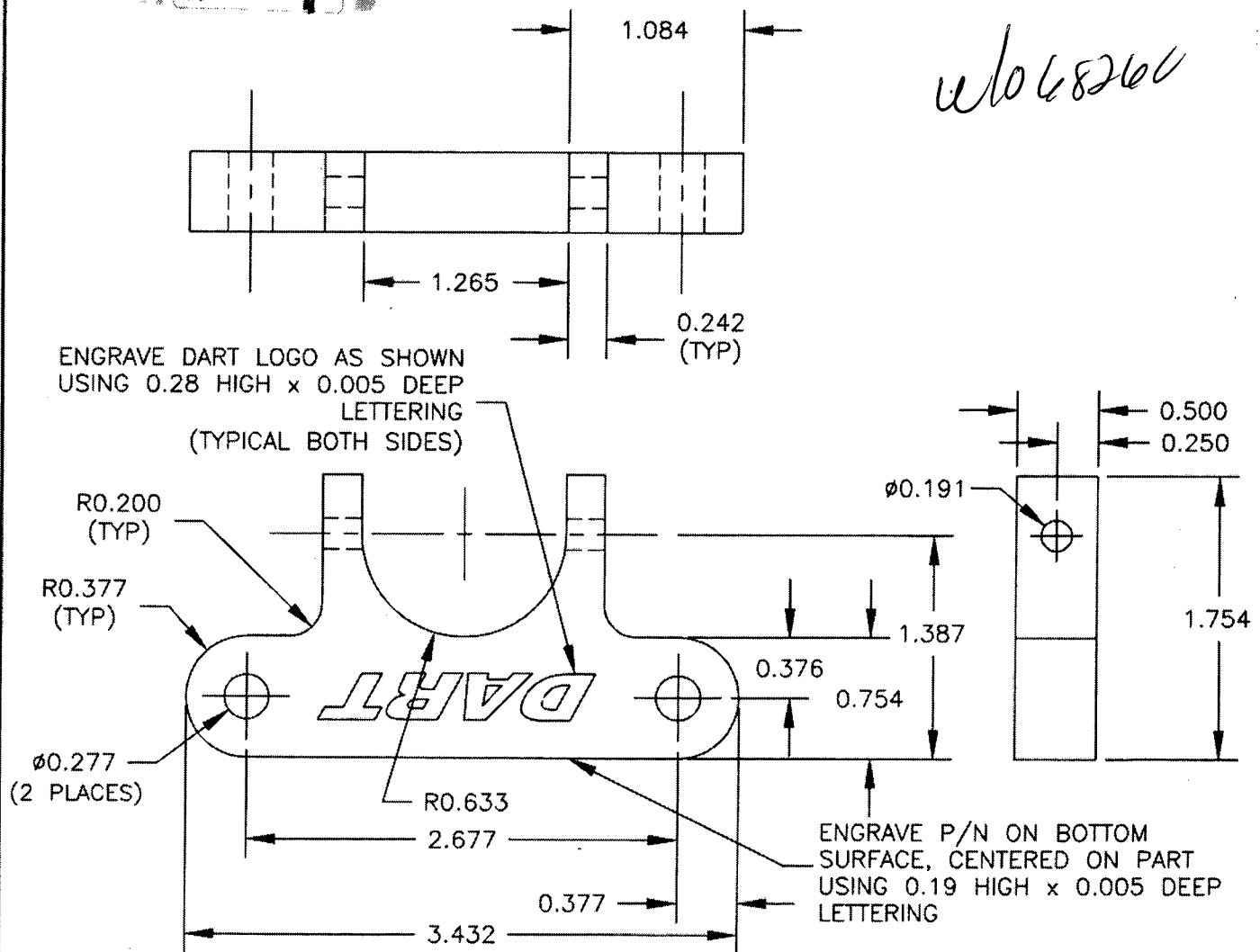
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

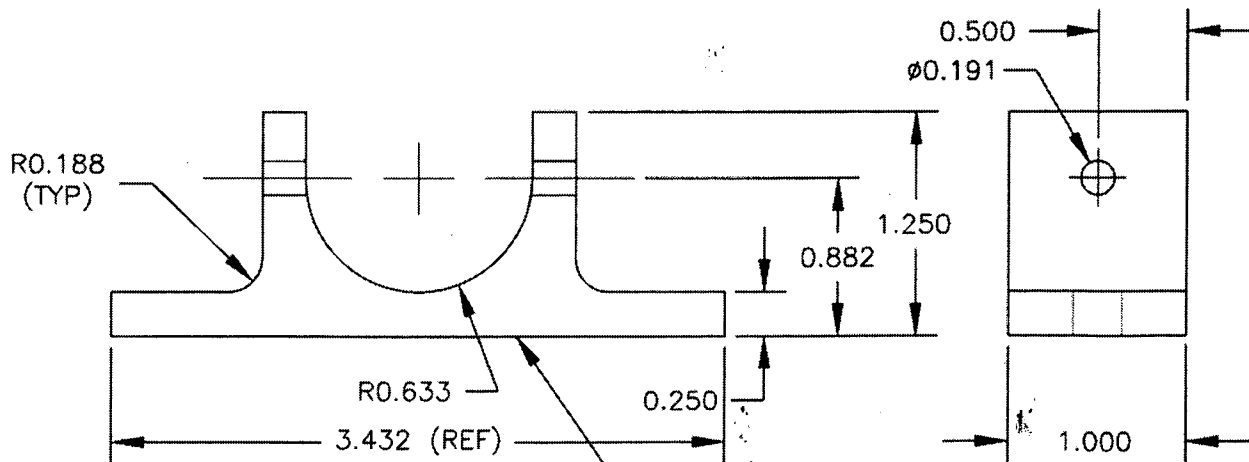
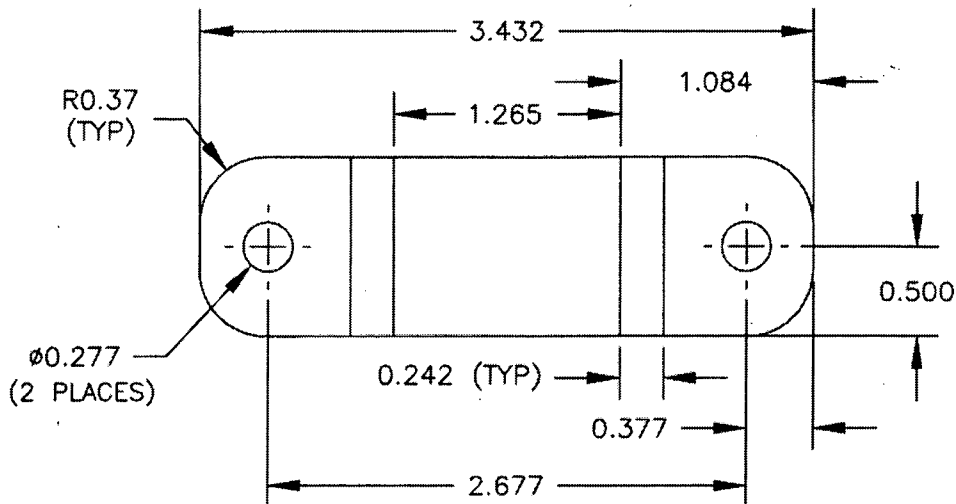
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



RELEASED
03.0.10

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries